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DART AEROSPACE LTD	Work Order:	19216
Description: Spacepod Hardware Kit	Part Number:	K10018
-1		
Dwg: D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C PF 03.04.30	Qty:	3 Kits

Page 1 of 2

RF
03.05.22

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg NOT RECD FOR THIS W/LO Note: K10018 Kit to be made in multiples of 7. (1) K10018 requires (2) D2174-041. (1) D2174-041 consists of (1) D2174-1 Web & (2) D2175 Angle	KJ	03.05.22	3
2	MV	Cut blanks: (12.000" x 3.850") Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) Use stack of 7 Identify for D2174-1 Batch:			
3	MV	Cut (2) blanks per (1) K10018 Kit Cut blanks: (12.200" x 2.960") grain along 2.960 Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) Use stack of 7 Identify for D2175 Batch:			
4	MV	Machine D2174-1 as per Folio FA097 and Dwg D2174-1 Identify as D2174-1			
5	QC2	Inspect parts as they come off the CNC machine			
6	MV	Deburr for measurement			
7	QC8	Second check			
8	MV	Machine D2175 as per Folio FA083 and Dwg D2175 Identify as D2175			
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr for measurement			
11	QC8	Second check			
12	GA	Deburr D2174-1 and D2175 stacks			
13	GB	Form D2175 Angle as per Dwg D2175			
14	QC5	Inspect work to Step 13			
15	FP	Chemical Conversion Coat per QSI 005 4.1 and Dwg D2174-1 and D2175			
16	QC3	Inspect work to Step 15			
17	GA	Assemble D2174-1 and D2175 as per Dwg D2174-041 Pick: <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 23 MS20470AD4-6 Rivet			
18	QC5	Identify as D2174-041 Inspect work to Step 17			
19	FP	Powder Coat White (Ref: 4.3.5.1) as per QSI 005 4.3			
20	QC3	Inspect Powder Coat. Go to KP cell for packing.			

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
		Initial							

PAR#: _____

Fault Category: _____

DQA: _____

Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____

Date: _____

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-1 Dwg: D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C	Qty:	3 Kits
RF 03.04.30		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																																																
21	KP	Pick: Packing Kit (Note: D2174-041 is not on the BOM, but is in as material from steps 2 & 3) <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2174-041</td> <td>Web Assembly</td> <td>B16562/B13732</td> </tr> <tr> <td>1</td> <td>D2985</td> <td>Decal</td> <td>B14160</td> </tr> <tr> <td>8</td> <td>A3235-020-935</td> <td>Washer</td> <td></td> </tr> <tr> <td>16</td> <td>AKS7-1032-130</td> <td>Insert ALS4-1032-130</td> <td>M11912</td> </tr> <tr> <td>8</td> <td>AN3-3A</td> <td>Bolt</td> <td>M3155</td> </tr> <tr> <td>8</td> <td>AN3H4A</td> <td>Bolt (or AN3H4)</td> <td>M12493</td> </tr> <tr> <td>36</td> <td>AN525-10R7</td> <td>Screw</td> <td>M11822</td> </tr> <tr> <td>8</td> <td>AN960JD10</td> <td>Washer</td> <td>M6140</td> </tr> <tr> <td>16</td> <td>AN960JD10L</td> <td>Washer</td> <td>M12749</td> </tr> <tr> <td>16</td> <td>MS21042L3</td> <td>Nut (or -3)</td> <td>M12241</td> </tr> <tr> <td>8</td> <td>MS24694S67</td> <td>Screw</td> <td>M9404</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	D2174-041	Web Assembly	B16562/B13732	1	D2985	Decal	B14160	8	A3235-020-935	Washer		16	AKS7-1032-130	Insert ALS4-1032-130	M11912	8	AN3-3A	Bolt	M3155	8	AN3H4A	Bolt (or AN3H4)	M12493	36	AN525-10R7	Screw	M11822	8	AN960JD10	Washer	M6140	16	AN960JD10L	Washer	M12749	16	MS21042L3	Nut (or -3)	M12241	8	MS24694S67	Screw	M9404	{B}	03.04.26	3
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22	QC4	Inspect Kit 100% for Completeness on the W/O	{B}	03.04.23	3																																																
23	ST	Identify and Stock	{B}	03.04.23	3																																																
24	AC	Cost / part 61.54	SAC	03-06-24	3																																																
25	DC	Close W/O 61.54 Inspect Level 21	{B}	03.06.23																																																	

Rev	Date	Change	Revised By	Approved
A	03.03.26	New issue	KJ/RF	#

RELEASED
03.04.30 KF

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 22, 2003
01:41 pm

Work Order No	:	0019216	Department Code:
Project Name	:	K10018	Burden Flags : NNNNNNNN
Project For	:	WK324	0 Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	K10018	Invoice Number :
Description	:	Spacepod Hardware Kit	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	3	
Amount Done	:	0	Order Entry No :
Start Date	:	05-22-03	Value : 0.00
Est Finish Date	:	06-12-03	
Act Finish Date	:		Net Margin : 0.000%
Drawings Reqd	:	No	Actual Margin : 0.000%
Ok for Approval	:		
Approval Rec'd	:		Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Testing Hours	: 0.00	0.00	0.00		
Testing Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
SubContract Hours	: 0.00	0.00	0.00		
SubContract	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
 Burden	 :	 0.00	 0.00	 0.00	
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00